



**Work Order ID 161254**

Tuesday, May 09, 2017 3:22:49 PM

**\*161254\***

Page 2

Item ID: D3394-3RG Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Lug  
Start Date: 5/9/2017 Start Qty: 16.00 **\*16\*** Cust Item ID:  
Required Date: 5/11/2017 Req'd Qty: 16.00 **\*16\*** Customer:  
Reference: SCHEDULED/C

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description                           | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|----------------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 120                            | Identify as per dwg & Stock Location: <i>Stesa</i> | 0.00                 |         |        |              |               |               |                  |                |
| <b>*120*</b>                   |                                                    |                      |         |        |              |               |               |                  |                |
| Packaging                      | Memo                                               | 0.16                 |         |        |              |               |               |                  |                |
| Packaging                      |                                                    |                      |         |        |              |               |               |                  |                |
| 130                            | QC21- Final Inspection - Work Order Release        | 0.00                 |         |        |              |               |               |                  |                |
| <b>*130*</b>                   |                                                    |                      |         |        |              |               |               |                  |                |
| QC                             | Memo                                               | 1.60                 |         |        |              |               |               |                  |                |
| Quality Control                |                                                    |                      |         |        |              |               |               |                  |                |

*20* *DAS 6 9-89* *JUN 28 2017*

*17/7/3* *DAS 21 9-89* *JUN 28 2017*

# Picklist Print

Tuesday, May 09, 2017 3:22:52 PM

Page 1

Work Order ID: 161254

**\*161254\***

Parent Item: D3394-3RG

**\*D3394-3RG\***

Parent Item Name: Lug

Start Date: 5/9/2017

Required Date: 5/11/2017

Start Qty: 16.00

Required Qty: 16.00

Comments: Ipp revA 11.05.27 new issue EC verified by:DD

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

D3394-3

Manufactured

No

100

Each

20.0000

1

16

**\*D3394-3\***

**\*\***

Lug

Location

Loc Qty

Loc Code

ST531

12

159260

12

ST532

8

140864

8

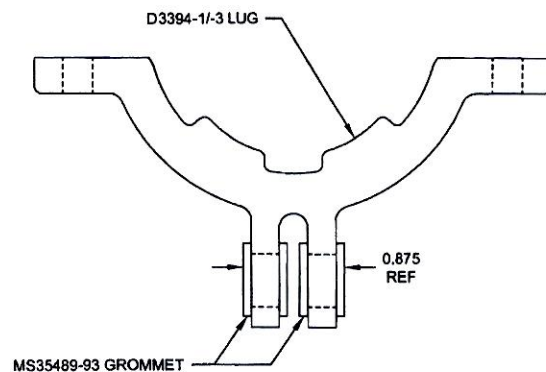
161479 SD

X20

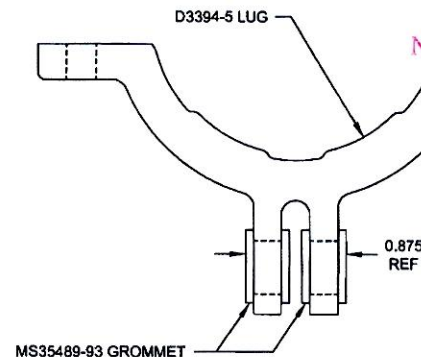
DAS  
41  
9-89

JUN 27 2017

| QTY.<br>-041 | QTY.<br>-043 | QTY.<br>-045 | PART NUMBER | DESCRIPTION  |
|--------------|--------------|--------------|-------------|--------------|
| X            |              |              | D3394-041   | LUG ASSEMBLY |
|              | X            |              | D3394-043   | LUG ASSEMBLY |
|              |              | X            | D3394-045   | LUG ASSEMBLY |
| 1            |              |              | D3394-1     | LUG          |
|              | 1            |              | D3394-3     | LUG          |
|              |              | 1            | D3394-5     | LUG          |
| 2            | 2            | 2            | MS35489-93  | GROMMET      |



D3394-041/-043 LUG ASSEMBLY



D3394-045 LUG ASSEMBLY

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 161254  
MJS  
1705-09

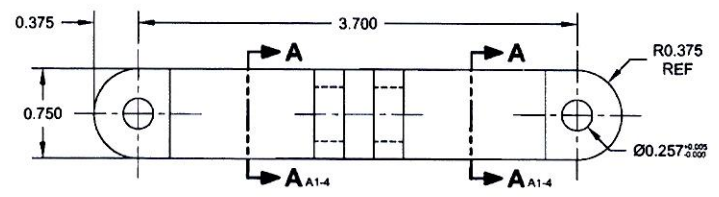
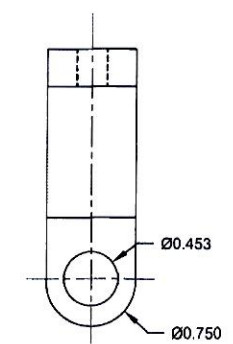
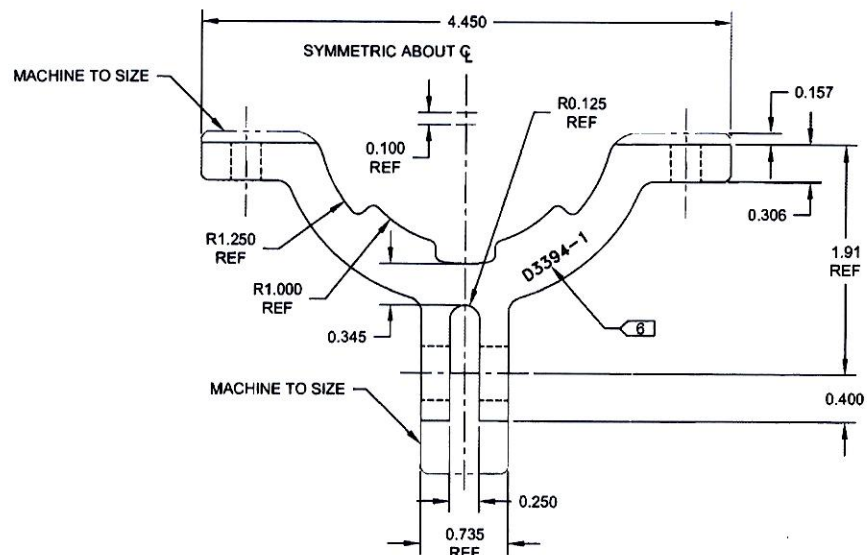
DEO ATTACHED

RELEASED  
09/04/02

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.20 lbs APPROX

| B          | ADDED -045. SHT 4 ADDED FILLETS IN SECTION A-A.<br>SEE PAR 152 | AJS                                                                                                                                                                                                                                                                                                 | 09.04.02     |
|------------|----------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| A          | NEW ISSUE                                                      | PH                                                                                                                                                                                                                                                                                                  | 05.02.14     |
| REV.       | DESCRIPTION                                                    | BY                                                                                                                                                                                                                                                                                                  | DATE         |
| DESIGN     | PH                                                             | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                                            |              |
| DRAWN      | AJS                                                            |                                                                                                                                                                                                                                                                                                     |              |
| CHECKED    |                                                                | DRAWING NO.                                                                                                                                                                                                                                                                                         | REV. B       |
| MFG. APPR. |                                                                | D3394                                                                                                                                                                                                                                                                                               | SHEET 1 OF 4 |
| APPROVED   |                                                                | TITLE                                                                                                                                                                                                                                                                                               | SCALE        |
| DE APPR.   |                                                                | LUG                                                                                                                                                                                                                                                                                                 | NTS          |
| DATE       | 09.04.02                                                       | <small>COPYRIGHT © 2005 BY DART AEROSPACE LTD<br/> THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS<br/> NOT TO BE USED FOR ANY PURPOSE OR COMBOD OR COMMUNICATED TO ANY OTHER PERSON WITHOUT<br/> WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> |              |



D3394-1 LUG

NOTES:

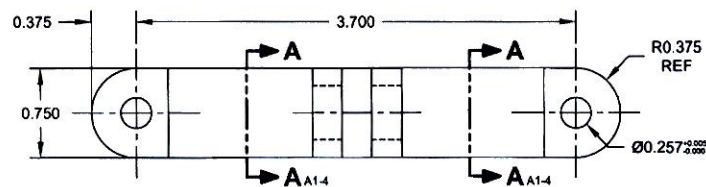
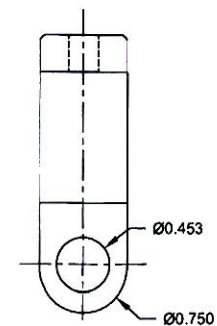
- 1) MATERIAL: MAKE FROM D2423
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO DEPTH OF 0.010±0.005 IN THIS LOCATION.  
WITH TOOL A TIP RADIUS OF 0.015±0.005
- 7) WEIGHT: 0.18 lbs

DEO ATTACHED

RELEASED  
09/06/25

|           |          |                                                                                                                                                                                                                                                                                              |              |
|-----------|----------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN    | PH       | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                                     |              |
| DRAWN     | A.S.     |                                                                                                                                                                                                                                                                                              |              |
| CHECKED   |          | DRAWING NO                                                                                                                                                                                                                                                                                   | REV. B       |
| MFG. APPR |          | D3394                                                                                                                                                                                                                                                                                        | SHEET 2 OF 4 |
| APPROVED  |          | TITLE                                                                                                                                                                                                                                                                                        | SCALE        |
| DE APPR   |          | LUG                                                                                                                                                                                                                                                                                          | NTS          |
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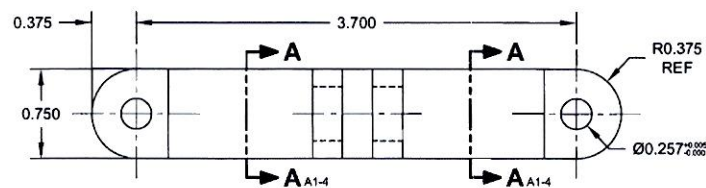
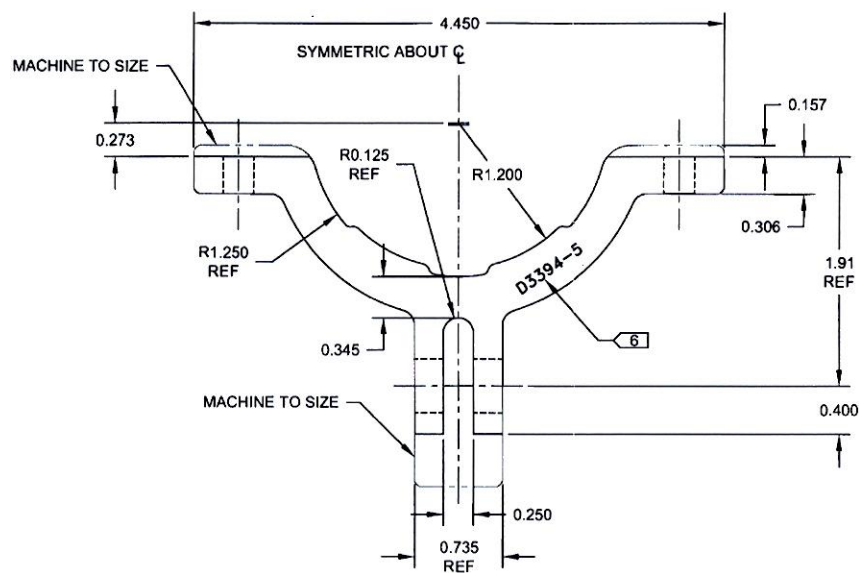


**DEO ATTACHED**

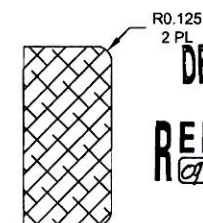
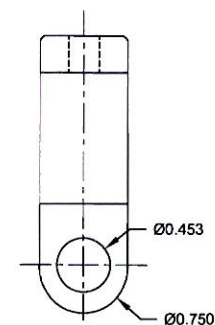
RELEASED  
09/06/25 NW

1) MATERIAL: MAKE FROM D2423  
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: ENGRAVE PART NUMBER TO DEPTH OF 0.010±0.005 IN THIS LOCATION,  
WITH TOOL A TIP RADIUS OF 0.015±0.005  
7) WEIGHT: 0.18 lbs

|            |                                                                                       |                                                                                                                                                                                                                                                                            |              |
|------------|---------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN     | PH                                                                                    | <b>DART AEROSPACE LTD</b>                                                                                                                                                                                                                                                  |              |
| DRAWN      | AJS                                                                                   | HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                                                |              |
| CHECKED    |  | DRAWING NO.                                                                                                                                                                                                                                                                | REV. 1       |
| MFG. APPR. |                                                                                       | D3394                                                                                                                                                                                                                                                                      | SHEET 3 OF 4 |
| APPROVED   |                                                                                       | TITLE                                                                                                                                                                                                                                                                      | SCALE        |
| DE APPR.   |                                                                                       | LUG                                                                                                                                                                                                                                                                        | NT           |
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**D3394-5 LUG**



**SECTION A-A**

DEO ATTACHED  
RELEASED  
09/06/25 MJP

**NOTES:**

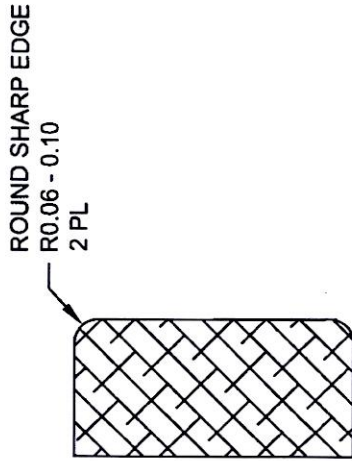
- 1) MATERIAL: MAKE FROM D2423
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO DEPTH OF 0.010±0.005 IN THIS LOCATION,  
WITH TOOL A TIP RADIUS OF 0.015±0.005
- 7) WEIGHT: 0.18 lbs

|                                                                                                                                                                                                                                |                                                                                       |                                        |              |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------|----------------------------------------|--------------|
| DESIGN                                                                                                                                                                                                                         | PH                                                                                    | <b>DART AEROSPACE LTD</b>              |              |
| DRAWN                                                                                                                                                                                                                          | AJS                                                                                   | HAWKESBURY, ONTARIO, CANADA            |              |
| CHECKED                                                                                                                                                                                                                        |                                                                                       | DRAWING NO.                            | REV. B       |
| MFG APPR.                                                                                                                                                                                                                      |  | D3394                                  | SHEET 4 OF 4 |
| APPROVED                                                                                                                                                                                                                       |                                                                                       | TITLE                                  | SCALE        |
| DE APPR.                                                                                                                                                                                                                       |  | LUG                                    | NT           |
| DATE                                                                                                                                                                                                                           | 09.04.02                                                                              | COPYRIGHT © 2005 BY DART AEROSPACE LTD |              |
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|                      |                  |        |                                         |                  |                         |                           |              |
|----------------------|------------------|--------|-----------------------------------------|------------------|-------------------------|---------------------------|--------------|
| DRAWING NO.<br>D3394 | TITLE<br>LUG     | REV. B | DART AEROSPACE LTD<br>ENGINEERING ORDER |                  | D.E.O. NO.<br>D3394-B-1 | SHEET NO.<br>SHEET 1 OF 1 | SCALE<br>NTS |
| DRAWN<br>AJS         | CHECKED          |        | MFG. APPR.                              | APPROVED         |                         | DE APPR.                  |              |
| DATE<br>09.11.04     | DATE<br>09.11.04 |        | DATE<br>09.11.04                        | DATE<br>09.11.04 |                         | DATE<br>09.11.04          |              |

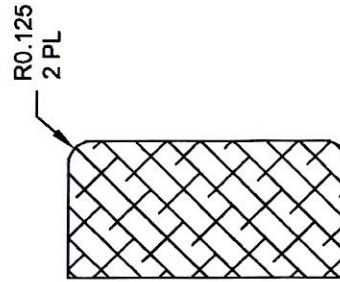
SHEET 4 ZONE A,1 MODIFY SECTION A-A AS SHOWN:

IS:



SECTION A-A

WAS:



SECTION A-A

REASON: DRAFTING ERROR

**RELEASED**  
2009-11-25  
WAD



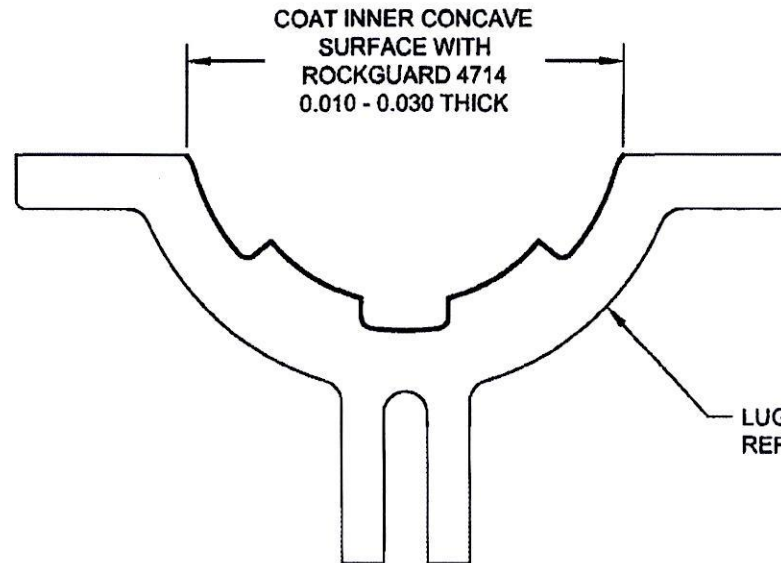
|                      |                   |                     |                                              |  |                         |                           |              |
|----------------------|-------------------|---------------------|----------------------------------------------|--|-------------------------|---------------------------|--------------|
| DRAWING NO.<br>D3394 | TITLE<br>LUG      | REV. B              | DART AEROSPACE USA, INC<br>ENGINEERING ORDER |  | D.E.O. NO.<br>D3394-B-2 | SHEET NO.<br>SHEET 1 OF 1 | SCALE<br>NTS |
| DRAWN <i>GP</i>      | CHECKED <i>SC</i> | MFG. APPR. <i>M</i> | APPROVED <i>MP</i>                           |  | DE APPR. <i>H</i>       |                           |              |
| DATE 11.05.02        | DATE 11.05.09     | DATE 11.05.09       | DATE 11.05.09                                |  | DATE 11.05.09           |                           |              |

**PURPOSE**

ADD D3394-xRG OPTION

**CHANGE**

D3394-xRG MOUNTING LUGS ARE INDENTICAL TO D3394-x MOUNTING LUGS, HOWEVER AFTER FINISH, COAT INNER CONCAVE SURFACE WITH "PLUS ONE ROCKGUARD 4714" AS SHOWN BELOW.



**D3394-1RG LUG (SHOWN)**  
**D3394-3RG/-5RG LUGS (SIMILAR)**  
**D3394-041RG/-043RG/-045RG LUG ASSEMBLIES (SIMILAR)**

**RELEASED**  
 2011-05-21  
*LM*